

Date: Thursday, 20/11/2008 3:35:19 PM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : DOOR ASSEMBLY |
| Job Number : 43622 | |
| Estimate Number : 10712 | |
| P.O. Number : | Part Number : D32133 |
| This Issue : 20/11/2008 S.O. No. : | Drawing Number : D3213 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 42105 | Material : |
| Written By : | Due Date : 28/12/2008 Qty: 6 Um: Each |
| Checked & Approved By : <u>JUD 08.11.21</u> | |
| Comment : Est Rev:A New Issue 05-11-17 JLM | |
| Est Rev:B Now on Waterjet 07-02-13 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S063 | 2024-T3 .063 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.4950 sf(s)/Unit Total : 2.9698 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)Identify as D3213-3

Batch: 108415 HB 8-12-10



| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



A
A

HB 8-12-10



Comment: FLOW WATER JET

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



HB 8-12-10



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

508/12/10



| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr HB 8-12-10

| | | |
|-----|-----------------|----------------------------|
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/12/11



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:19 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43622

Part Number: D32133

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/12/11

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST180

SS 08/12/12

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/15

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-12-12

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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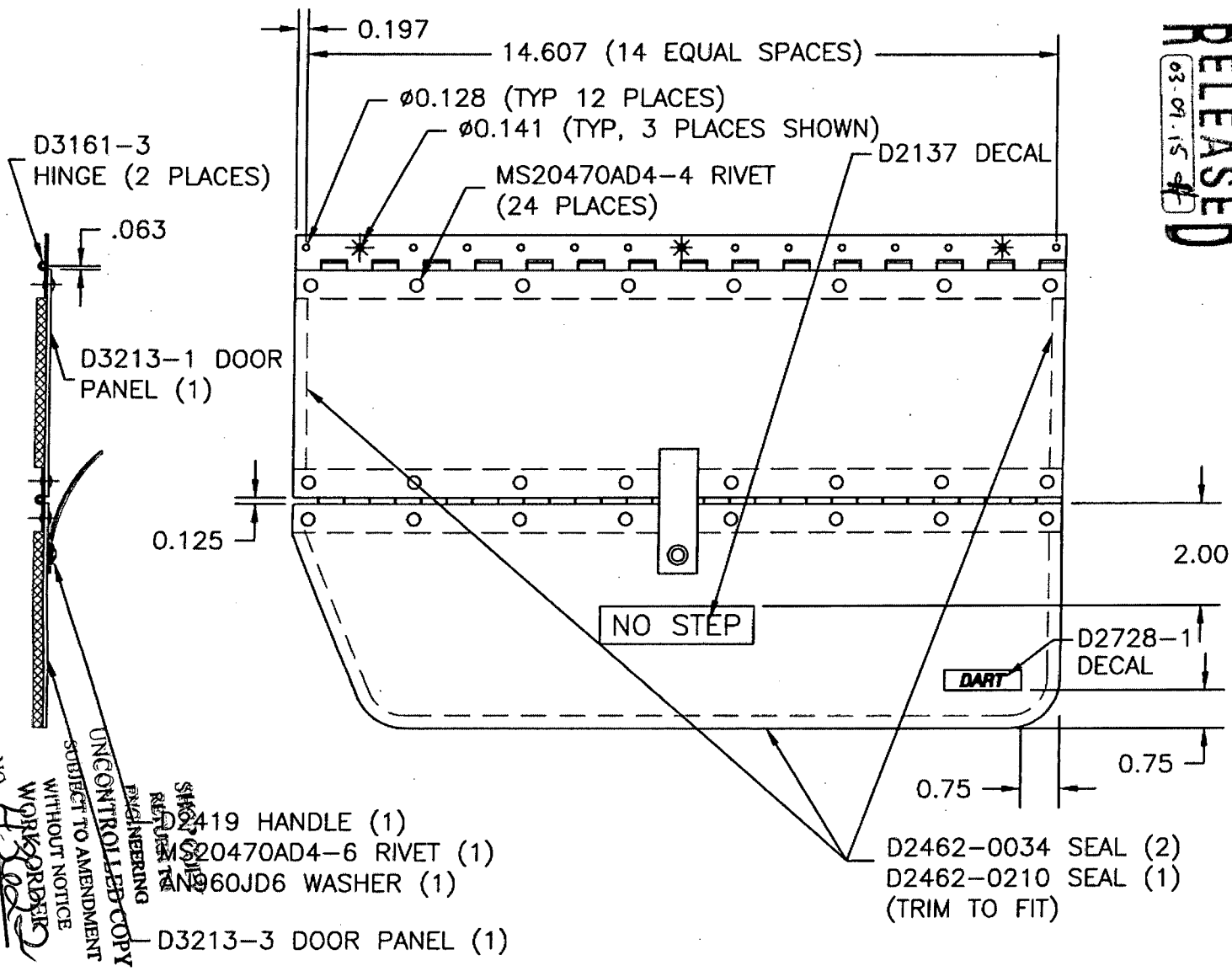
NOTE: Date & initial all entries

DART



RELEASED
03-09-15

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|----------------------------|-----------------------------|-----------------------------|
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE 03.09.03 | DRAWING NO. D3213 | REV. A |
| A | 03.09.03 | 1 OF 2 |
| | NEW ISSUE | SCALE 1:3 |
| | | |



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
 FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

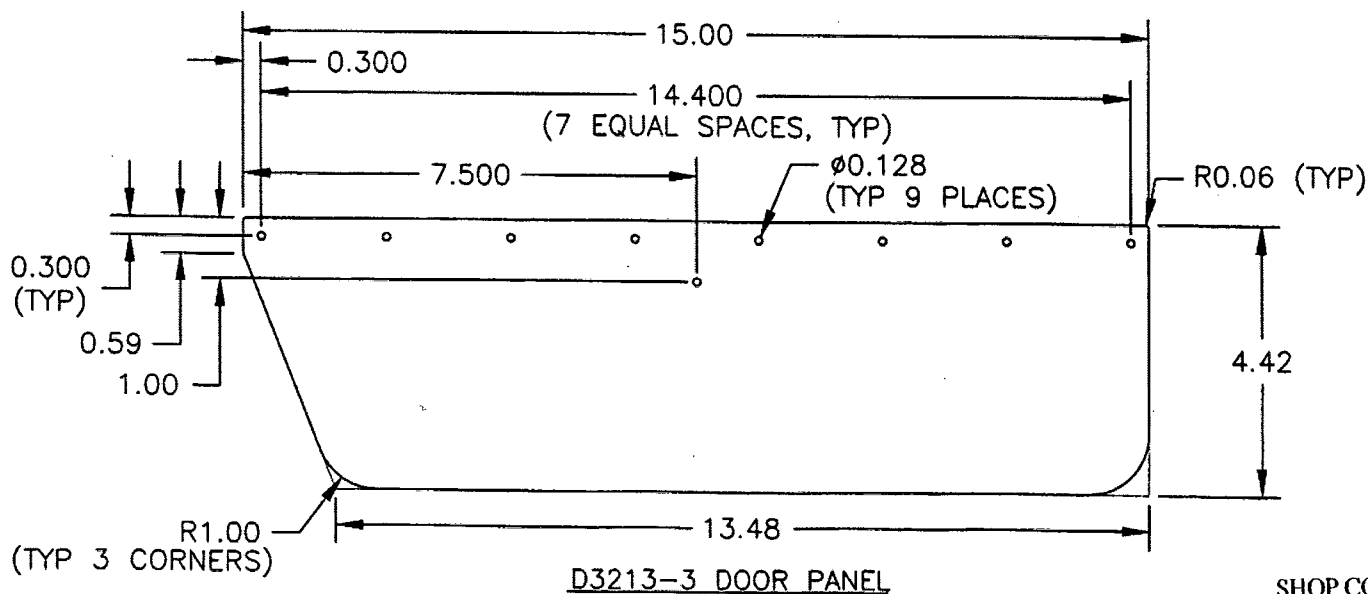
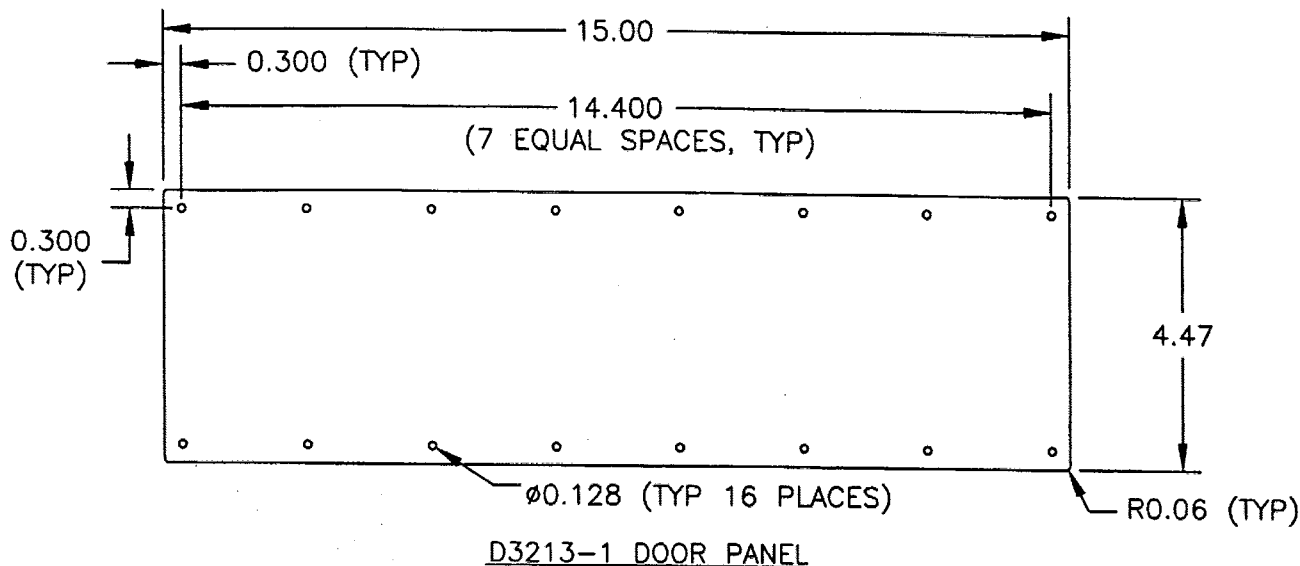
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| | | | |
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3213 | REV. A 2 OF 2 |
| DATE 03.09.03 | | TITLE DOOR ASSEMBLY | SCALE 1:3 |



D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15

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WORK ORDER

NO. 43625

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